

Work Order ID 152486***152486***

Page 1

Tuesday, October 25, 2016 9:28:09 AM

Item ID: D4880-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Strut

Start Date: 10/25/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 11/1/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: emDate: 10/10/25

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4880

C

SCRAP

100

100

Doosan

DOOSAN LATHE

Memo

1- Turn as per Folio FB245

Rev: AA & Dwg D4880 Rev: C

0.00

2.20

15 4 P16-10-26
DAS
45 16-10-26
9-89

2- Deburr

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.02

15 4 P16-10-26

DQA: duh Date: Jan 3 2017



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: duh Date: NOV 10 2016

Work Order update only ☐

Work Order: <u>152486</u> Part No. <u>D4880-1</u> NCR No. <u>16-6116</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Date: <u>16-10-27</u>	Step #: <u>100</u>	QTY Effective: <u>15</u>		MRB (QSI042) Approval																																																																	
Description Work Order Deviation		Disposition		Completed By																																																																	
inside scoring found in center of tube. Caused From Machin Process R.C. incorrect offset		Scrap + destroy no replace		<u>S 16/10/27</u>																																																																	
				Lead hand / Supervisor Approval Verification DAS <u>9</u> 9-89 <u>16-11-03</u>																																																																	
				QC / QA Coordinator Approval <u>S 16/10/27</u>																																																																	
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[illegible]

Work Order ID 152486

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152486

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Item ID: D4880-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Strut
Start Date: 10/25/2016 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 11/1/2016 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.03							
Quality Control									
160	Identify as per dwg & Stock Location: _____	0.00							
160									
Packaging	Memo	0.02							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.17							
Quality Control									

DAS
21
9-89

NOV 03 2016

Picklist Print

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Work Order ID: 152486

152486

Parent Item: D4880-1

D4880-1

Parent Item Name: Strut

Start Date: 10/25/2016

Required Date: 11/1/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 13.12.17 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174PH-H900R0.750		Purchased		No			f	27.0260		8			

M174PH-H900R0 750

17-4 SS H900 ROUND BAR 0.750"

Location

Loc Qty

Loc Code

MAT031

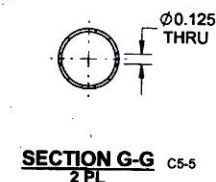
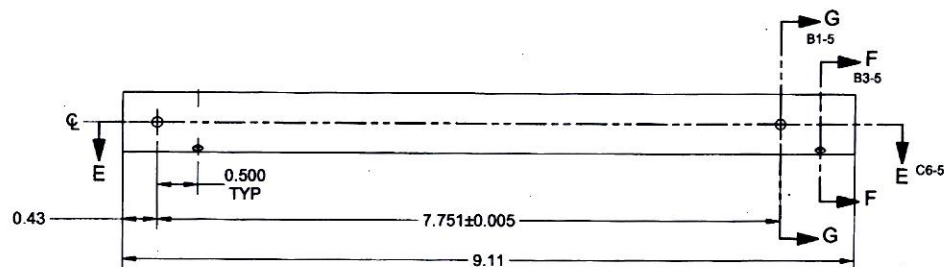
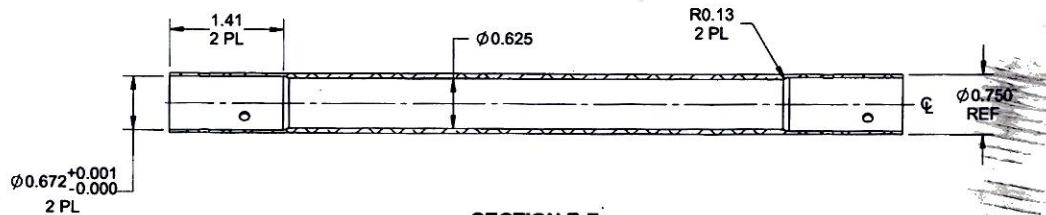
27.026

M129892

27.026

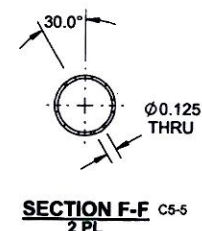
11.875 11-10-26

3634



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 152486

2m 16/10/25



D4880-1 STRUT

NOTES:

- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.6
- 7) WEIGHT: 0.31 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

RELEASED
2014-07-07

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	HS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D4880	SHEET 5 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
DATE	14.06.24	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
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